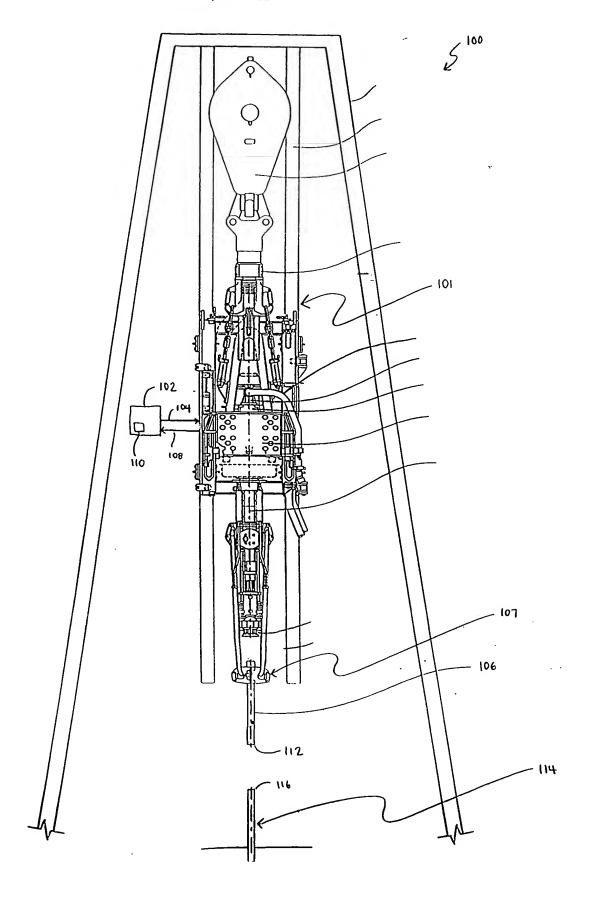
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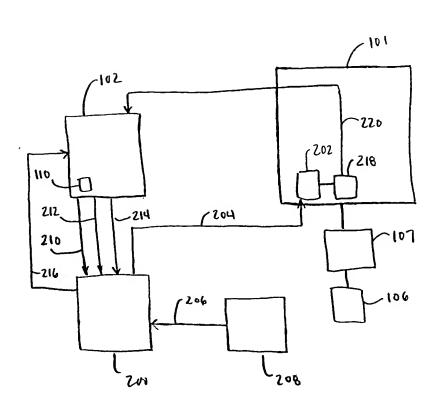
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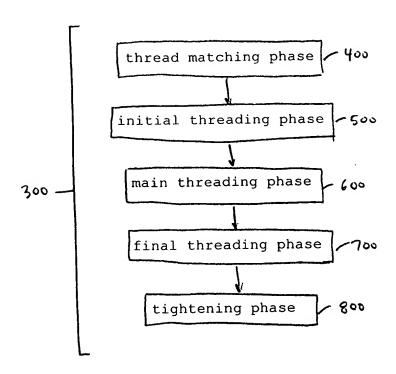


FIG. 3

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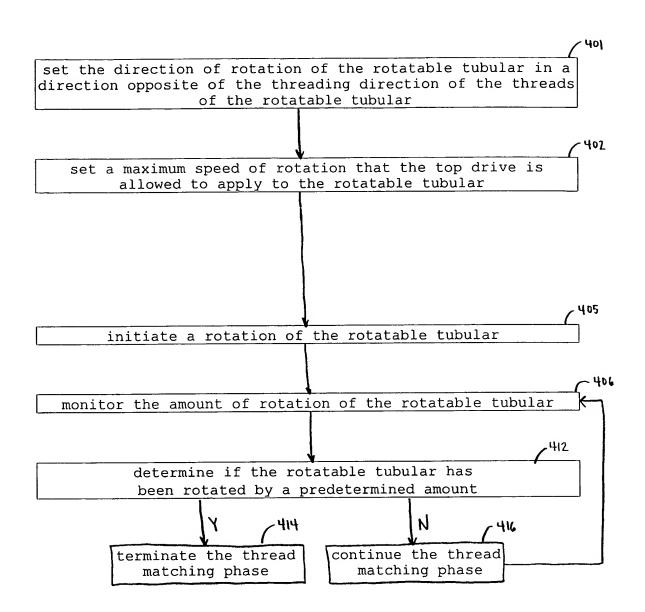


FIG. 4

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set the direction of rotation of the rotatable tubular in the threading direction of the threads of the rotatable 501 tubular set a maximum speed of rotation that the top drive is allowed to apply to the rotatable tubular set a limit for the torque that the top drive is allowed to ~ 504 apply to the rotatable tubular initiate a rotation of the rotatable tubular monitor the applied torque and the amount of rotation of the rotatable tubular determine if the torque limit has been reached -208 -512 210 determine if the rotatable halt the make-up process tubular has been rotated by a predetermined amount N -514 -516 continue the initial terminate the initial threading phase threading phase

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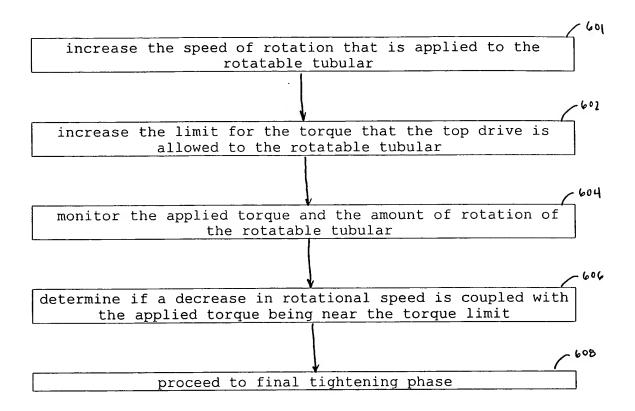
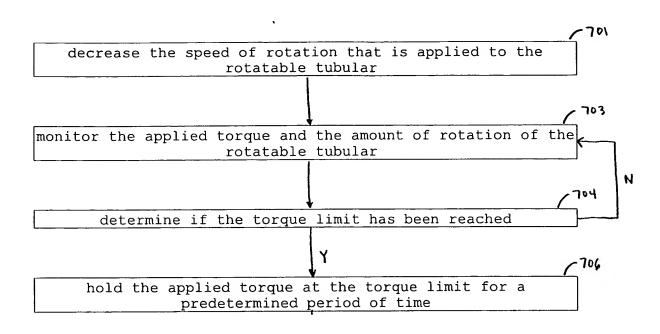


FIG. 6

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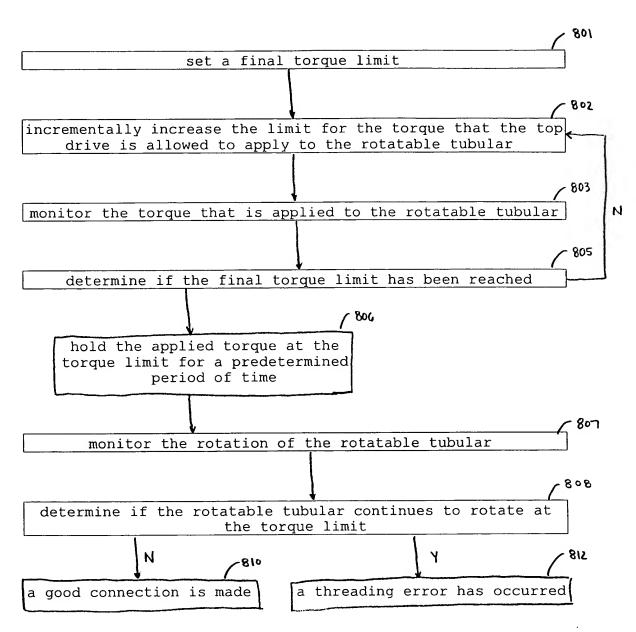


FIG. 8

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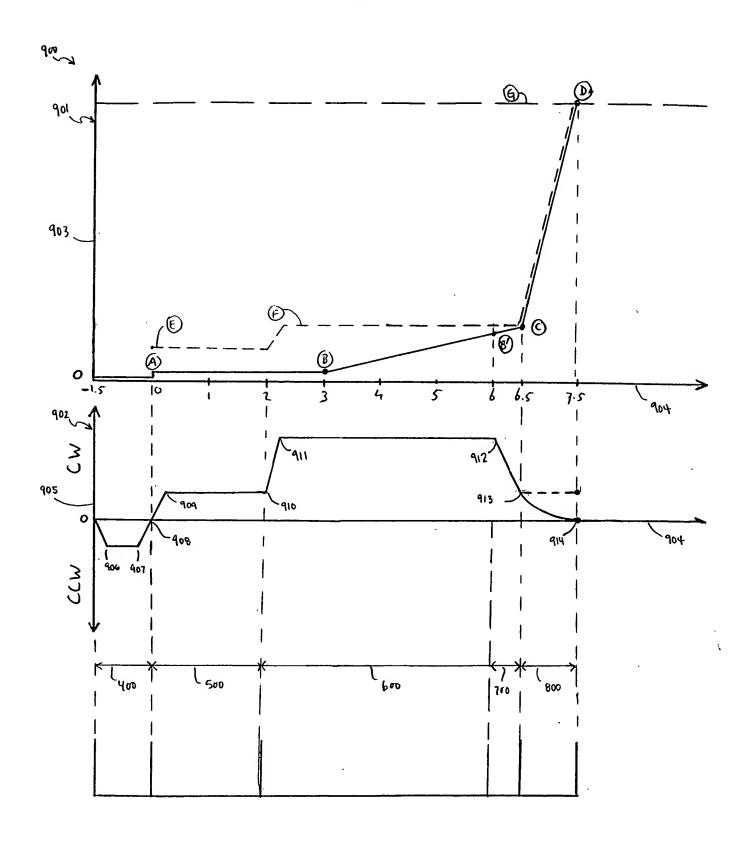
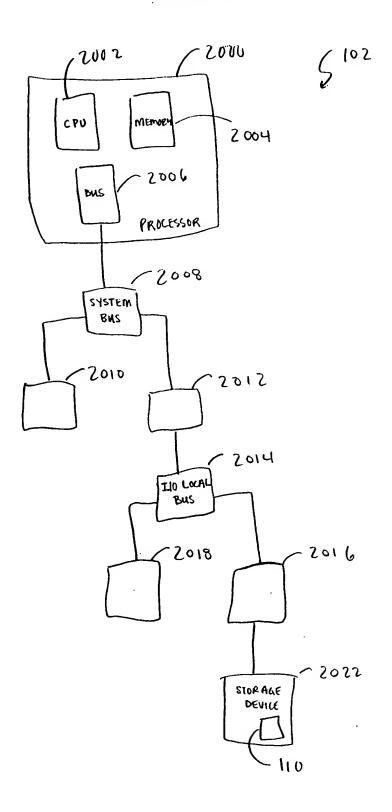


FIG. 9

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